

NON EUROCOPTER

Work Order ID 63712

November 10, 2010 12:41:34 PM



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 11/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG002

NON EUROCOPTER

8106148

H/S BG 10-11-16 (4)

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R Aluminum Rod

3-Grind End Plate flush

11108436
1114377

10-11-12

4

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Page 2

Item ID: D350-591-312

Accept

Revision ID:

Item Name: Heli-Access-Step, Long RH

Start Date: 11/10/10 Start Qty: 4.00

Required Date: 11/17/10 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: Date: Tooling:

QC: Date: SPC (Y/N):

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4 0 BE 10/11/15

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

4 RH 10-11-15

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 10/11/15

Work Order ID 63712

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Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop



Start Date: 11/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-11-16

4

φ

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod *M108436*

6-Grind End Plate flush

7-Install last rivet as per Dwg.

10-11-16

4

φ

Work Order ID 63712

Page 4

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Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 11/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4 0 BE 10/11/16

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sow 16



210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 RH - BL 10-11-16

Work Order ID 63712

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Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop



Start Date: 11/10/10 Start Qty: 4.00



Required Date: 11/17/10 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____
QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Run Start



Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M115291

Memo

0.00

START TIME: *9:00*

OVEN TEMPERATURE: *320°*

FINISH TIME: *9:30*

Powder Coating

N *BL 10-11-17*

230

Wing Walk as per dwg QSI005 4.4 Batch *M115790 => M*

0.00



HandFinish

Memo

Hand Finishing

10/11/17

4 *Ø*

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/11/18 (4)

Work Order ID 63712

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Page 6

Item ID: D350-591-312

Accept

Revision ID:

Item Name: Heli-Access-Step, Long RH

Start Date: 11/10/10 Start Qty: 4.00

Required Date: 11/17/10 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
Location: 72



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



10/11/10 S/ (40)

8/10/11/10

LC
R

DEW.D

10/11/10 S/

Work Order ID 63712

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Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 11/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N):

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
--------------------------------	--------------------------	----------------------

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

10/11/18

10-11-18
(4)

Picklist Print

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Page 1

Work Order ID: 63712

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH



Start Date: 11/10/10

Required Date: 11/17/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 04.03.22 New issue ! KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC IPP Rev:D
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-35A Bolt		Purchased	No			250	Each	106.0000	2	8			
-----------------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST353	106	
115457	6	
115936	100	

AN4-13A Bolt		Purchased	No			250	Each	400.0000	8	132			
-----------------	--	-----------	----	--	--	-----	------	----------	---	-----	--	--	--

Location	Loc Qty	Loc Code
ST357	400	
115936	300	
116075	100	

AN5-36A Bolt		Purchased	No			250	Each	117.0000	2	8			
-----------------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST340	100	
115936	100	
ST341	17	
114292	5	
114941	12	

Picklist Print

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Page 2

Work Order ID: 63712

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 11/10/10

Required Date: 11/17/10

Start Qty: 4.00

Required Qty: 4.00

AN960JD10\ NAS1149D0363J Purchased

No

250

Each

8.0000

4

16



Washer



M115622 10/11/10 SL

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD416 NAS1149D0463J Purchased

No

250

Each

24.0000

16

164



Washer



M116025 10/11/10 SL

Location

Loc Qty

Loc Code

ST300

24

113288

24

AN960JD516 NAS1149D0563J Purchased

No

250

Each

34.0000

4

16



Washer



M114742 10/11/10 SL

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

D2230-3 Manufactured

No

250

Each

30.0000

4

16



Lug



B62927 10/11/10 SL

Location

Loc Qty

Loc Code

ST476

30

55452

2

62660

28

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 63712

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 11/10/10

Required Date: 11/17/10

Start Qty: 4.00

Required Qty: 4.00

D2618



Bushing

Manufactured No

250

Each

103.0000

2

8



10/11/10

Location

Loc Qty

Loc Code

ST019

101

60772

1

62213

100

ST020

2

56892

1

57829

1

D2856-400



Abraison Strip

Manufactured No

250

f

142.2500

1.2

4.8



10/11/10

Location

Loc Qty

Loc Code

ST403

142.2500421

56626

0.00004211

59920

142.25

cut (2) D2856-400-720 as per dwg

D3065-041



Step Leg Assembly Hi

Manufactured No

180

Each

28.0000

1

4



10.11.15

Location

Loc Qty

Loc Code

WA

28

61216

3

62224

25

D3066-1



Spacer

Manufactured No

180

Each

87.0000

2

8



10.11.15

Location

Loc Qty

Loc Code

WA

87

62662

87

8

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Shop Packet Print

Page 3

Picklist Print

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Page 4

Work Order ID: 63712

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 11/10/10

Required Date: 11/17/10

Start Qty: 4.00

Required Qty: 4.00

D3067-1

Manufactured No

110 Each

136.0000

1 4



End Plate

Location

Loc Qty

Loc Code

WA

136

60141

5

62664

131

D3067-1

Manufactured No

180 Each

136.0000

1 4



End Plate

Location

Loc Qty

Loc Code

WA

136

60141

5

62664

131

D3219-1

Manufactured No

110 Each

61.0000

2 8



Plate

Location

Loc Qty

Loc Code

WA

61

61204

61

D3235-1

Manufactured No

250 Each

77.0000

2 8



Mounting Lug

Location

Loc Qty

Loc Code

ST471

77

61845

27

62214

50

D3272-1

Manufactured No

110 Each

0.0000

1 4



Step

11/10/10

11/10/10

11/10/10

B61845 10/11/10

11/10/10 363713

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Page 4

Picklist Print

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Page 5

Work Order ID: 63712

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 11/10/10

Required Date: 11/17/10

Start Qty: 4.00

Required Qty: 4.00

D3278-041

Manufactured No

250

Each

46.0000



Support Assembly

Location

Loc Qty

Loc Code

ST471

46

61212

16

62395

30

Each

2.0000

DS19410-011

Manufactured No



Step Modification

Location

Loc Qty

Loc Code

FG020

2

62191

2

Each

1,875.000

MS20600-AD4W4

Purchased No



Rivets

Location

Loc Qty

Loc Code

ST321

1875

113368

38

114181

11

114718

2

115573

147

115640

677

116022

1000

250

Each

1,817.000

MS21042L2

Purchased No



Nut

Location

Loc Qty

Loc Code

ST300

1817

114784

817

115835

1000

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Shop Packet Print

Page 5

Picklist Print

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Page 6

Work Order ID: 63712

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 11/10/10

Required Date: 11/17/10

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

250

Each

2,668.000

8

32



Nut



10/11/10 sl

Location

Loc Qty

Loc Code

ST300

2668

113422

25

114523

8

115589

1535

115621

1100

32

MS21042L5

Purchased

No

250

Each

1,393.000

2

8



Nut



10/11/10 sl (40)

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1367

115156

167

115594

500

116104

200

116105

500

8

November 10, 2010 12:41:33 PM

Shop Packet Print

Page 6

DART

DESIGN <i>QP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. E SHEET 1 OF 1
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

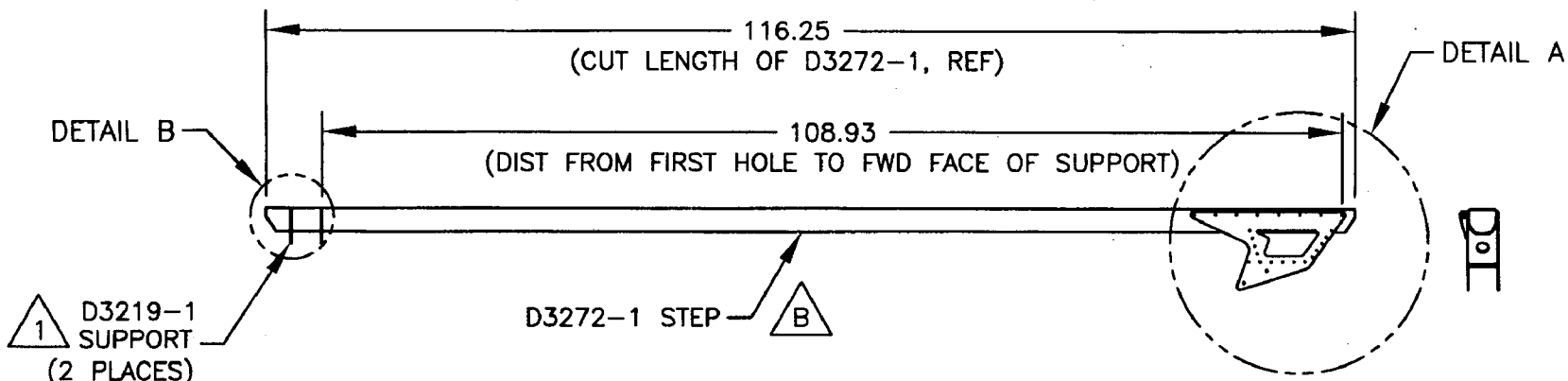
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

u/b 63712

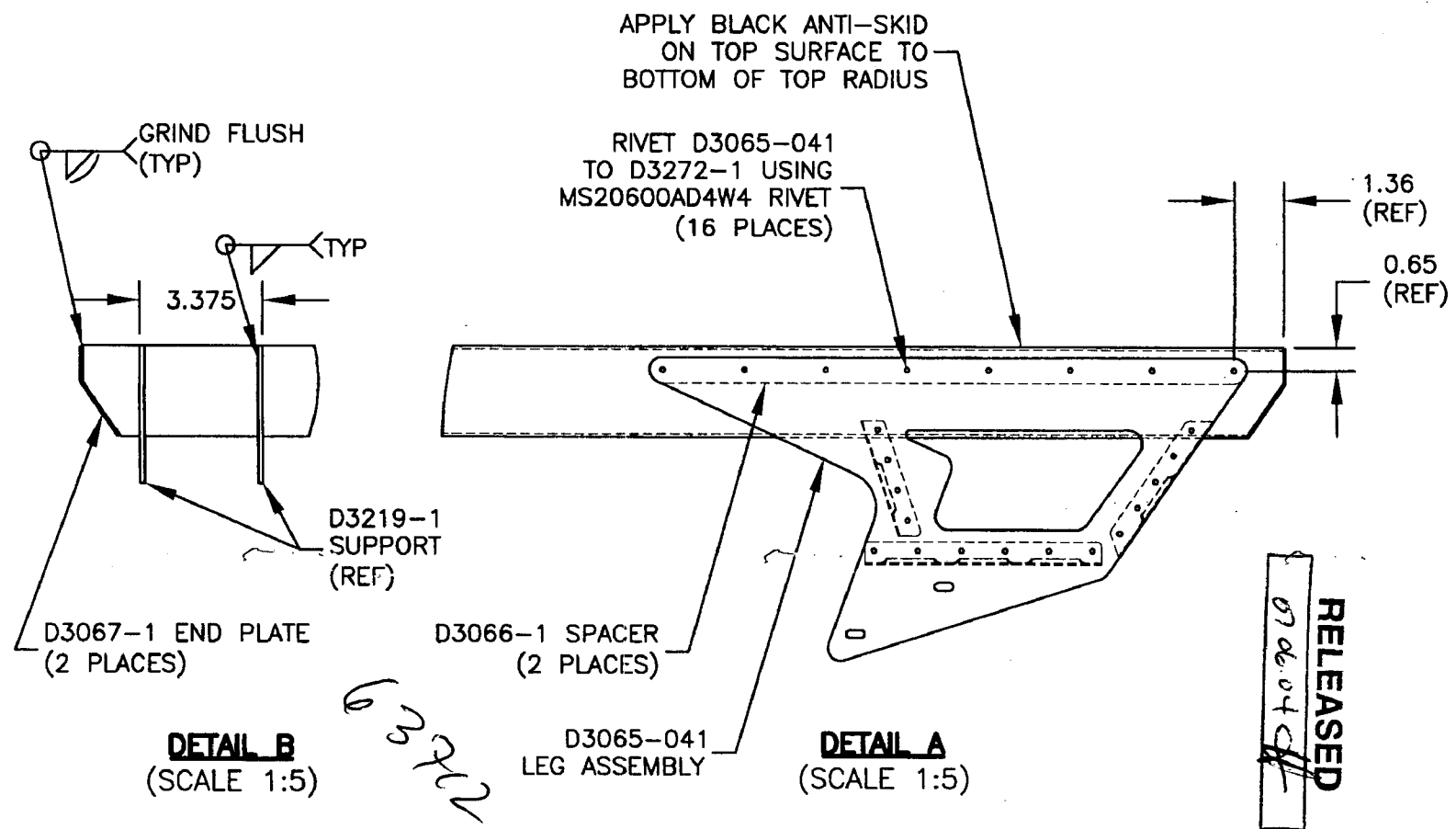


DESIGN	90	DRAWN BY	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. 'E'
CHECKED	CE	APPROVED	CE	DRAWING NO. D3272	SHEET 2 OF 2
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	SCALE	1:20

RELEASED
07.06.04



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

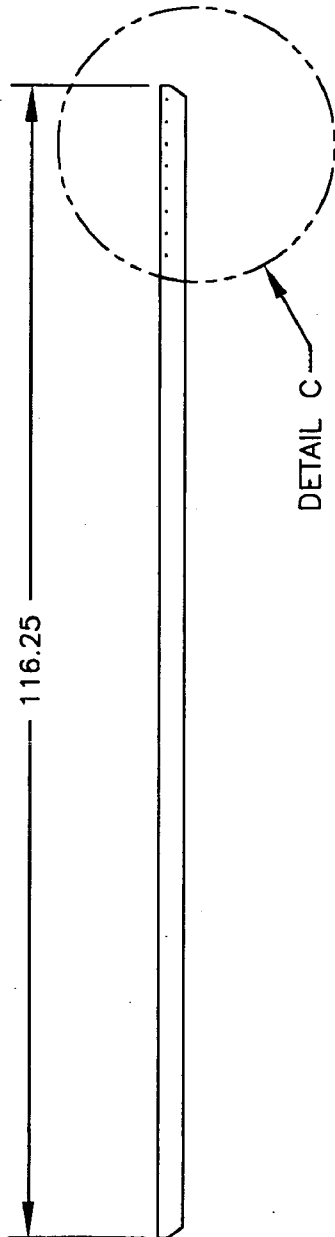




DESIGN 9P	DRAWN BY JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED JB	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

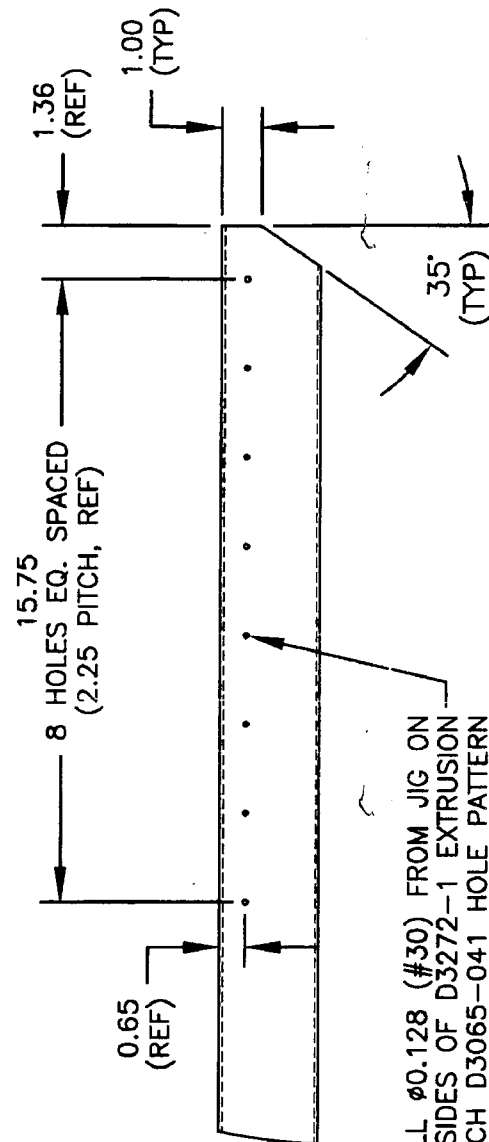
RELEASED

07.06.04



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

63712

REFERENCE ONLY

DART AEROSPACE LTD.

D350-591

Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: **G**
Date: 08.10.06